

# Work Order ID 76873

\*76873\*

Page 1

November-22-11 2:26:25 PM

Item ID: D3137-3 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Guide  
 Start Date: 22/11/2011 Start Qty: 20.00 ✓ \*20\* Cust Item ID:  
 Required Date: 06/12/2011 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/22 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3137	Rev F

100 0.00  
 \*100\* BAND SAW  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut Blanks. Blank size: 1.250" x .750" x .950" long

110 0.00  
 \*110\* HAAS CNC VERTICAL MACHINING #1  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 1-Machine as per Folio FA242 & Dwg D31372-Deburr

120 0.00  
 \*120\* QC Memo 0.00  
 Quality Control

add + inspect of anti-rust damage.  
 attached c/c to w/o

11/12/14 20  
 issue P/O to Archer P/O: 15679  
 machines as per dwg D 3137 REV. F  
 11/30 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76873****\*76873\***

Page 2

November-22-11 2:26:25 PM

Item ID: D3137-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID:  
Item Name: Guide Stop **\*NS2\***  
Start Date: 22/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 06/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC Inspect parts - second check 0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location **SI 235A** 0.00**\*140\***

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release 0.00

**\*150\***

QC

Memo

0.00

Quality Control

center  
20

SP 12-01-31

12/1/31

12-01-31  
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

November-22-11 2:26:28 PM

Page 1

Work Order ID: 76873

\*76873\*

Parent Item: D3137-3

\*D3137-3\*

Parent Item Name: Guide

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP Rev:A02.05.29New IssueNG

IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC

IPP Rev c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELRLNB0-75XL250

Purchased

No

100

f

31.0928

0.0791

1.665263

**\*MDFI-RINB0-75X1-250\***

\*\*

Delrin Bar

## Location

MAT055

## Loc Qty

31.0928

## Loc Code

117985

0.5328

118066

6.16

119133

24

14535

0.4

1.8 f 11/12/13

D 3137-3P

X 20

01/12/20 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

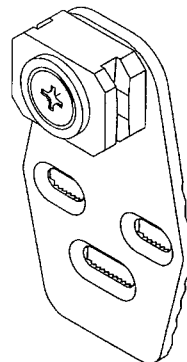
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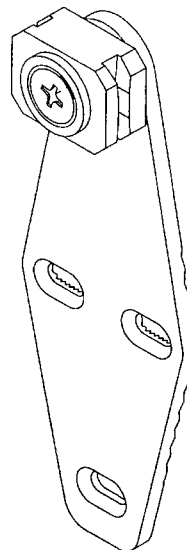
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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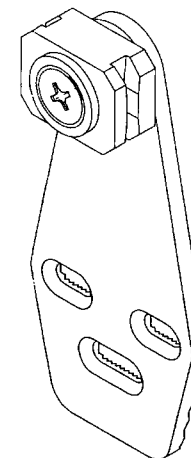
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 76873 M.L.J  
11/11/22



**D3137-041 BRACKET ASSEMBLY**







**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**RELEASE**  
 08-06-2022

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.8 0.67 DIM WAS 0.79, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.			AJS	08.05.30
E	ADD -045			RF	05.11.23
D	RE-DESIGN D2137-5; CHANGE DIMS			DS	04.11.03
C	ADD -043			DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP			DS	03.01.16
A	NEW ISSUE			DS	02.04.17
REV.	DESCRIPTION			BY	DATE
DESIGN	DS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS				
CHECKED			DRAWING NO.	REV. F	
MFG. APPR.			D3137	SHEET 1 OF 5	
APPROVED			TITLE	SCALE	
DE APPR.			BRACKET ASSEMBLY	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

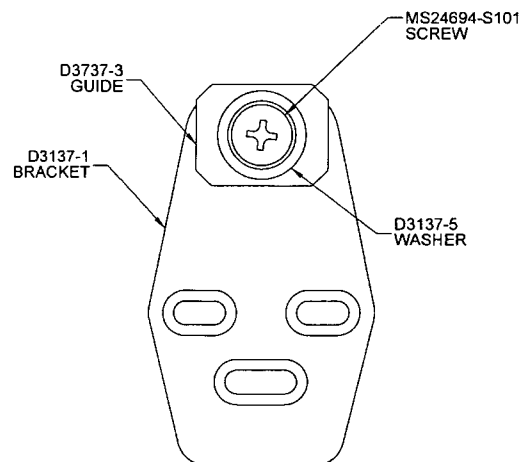
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

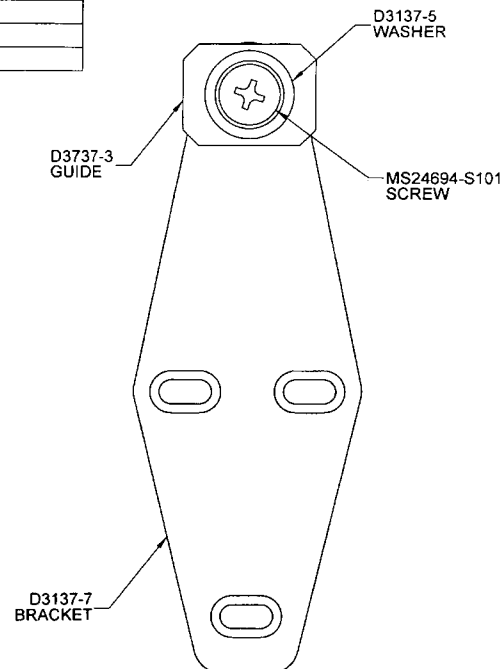


76873

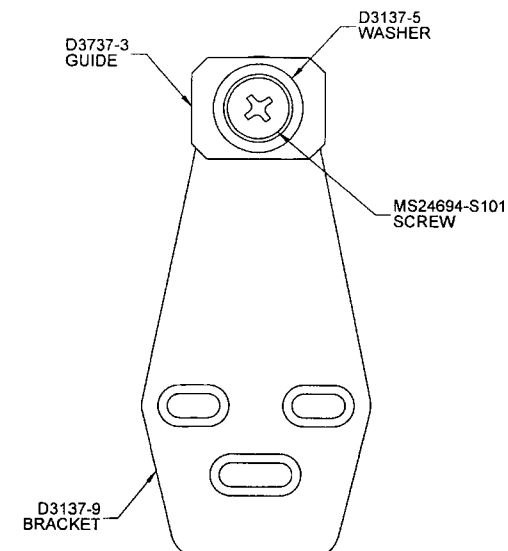
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

RELEASED  
28.06.26/10

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

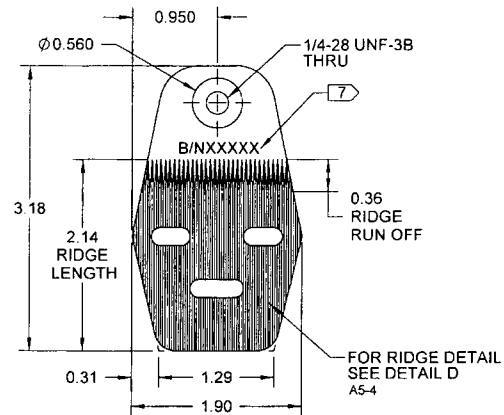
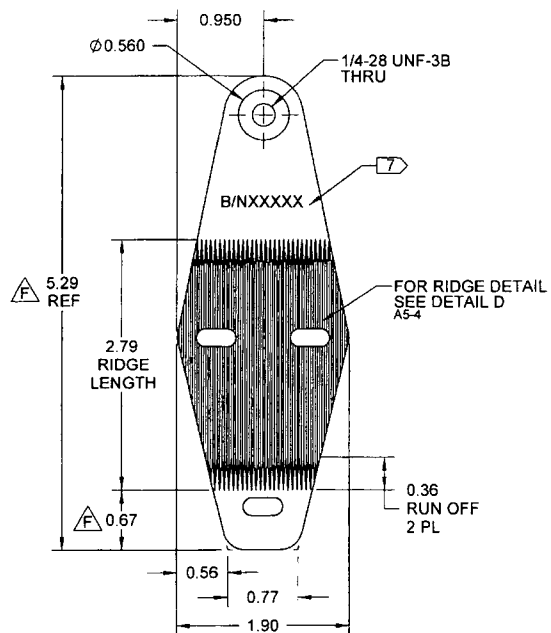
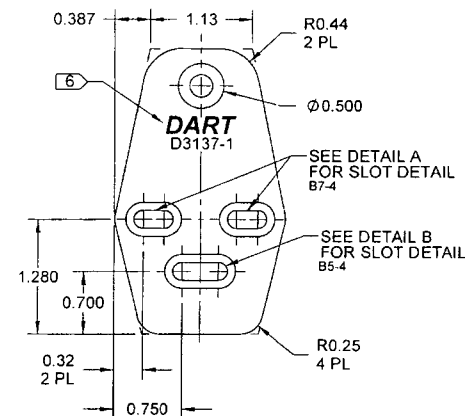
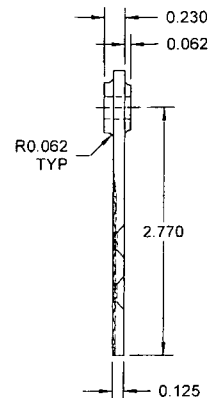
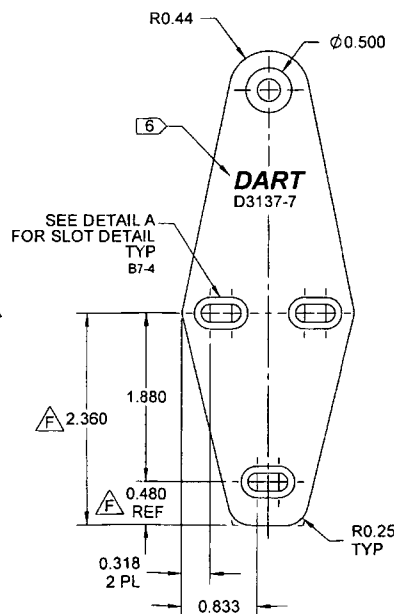
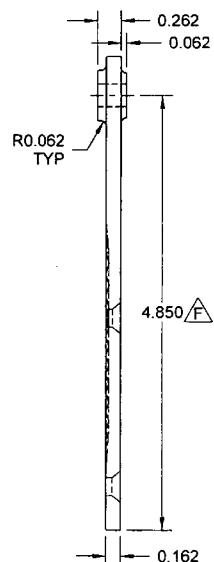
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76073

**D3137-1 BRACKET****D3137-7 BRACKET****NOTES:**

- 1) MATERIAL: -1 & -7  
17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-105

RELEASED  
08.05.30

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D3137</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

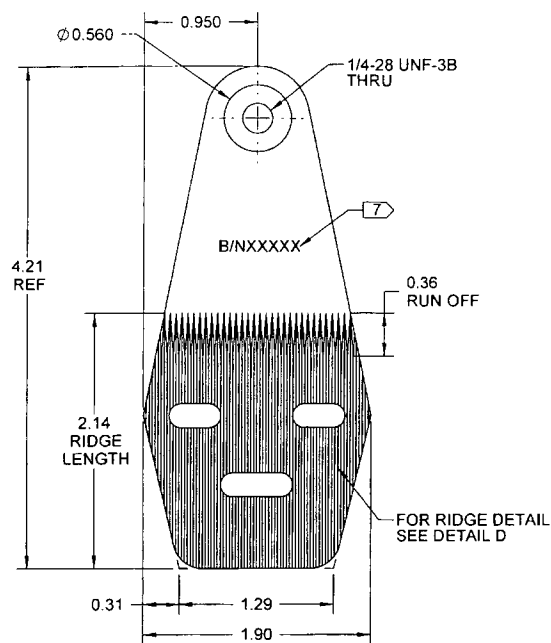
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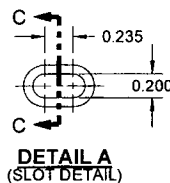
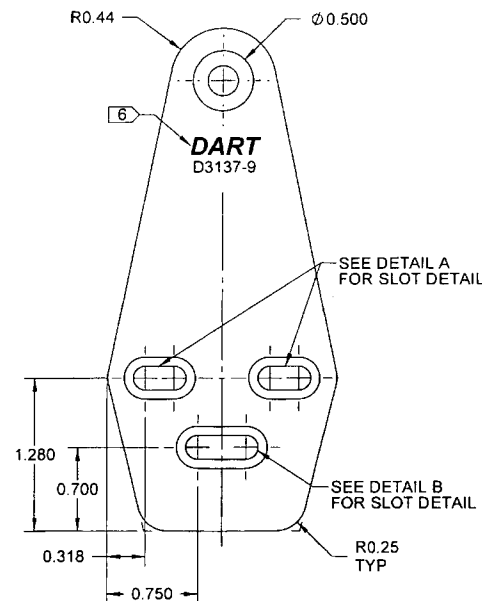
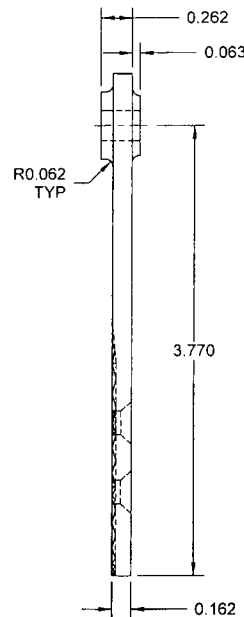
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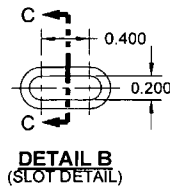
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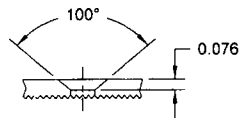
**D3137-9 BRACKET**



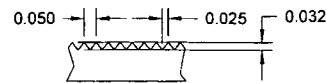
**DETAIL A  
(SLOT DETAIL)**



**DETAIL B  
(SLOT DETAIL)**



**SECTION C-C  
(SLOT DETAIL)**



**DETAIL D  
SCALE 2X  
(TYPICAL RIDGE DETAIL)**

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
  - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
  - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
  - 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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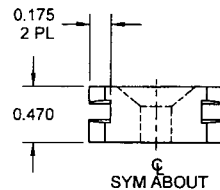
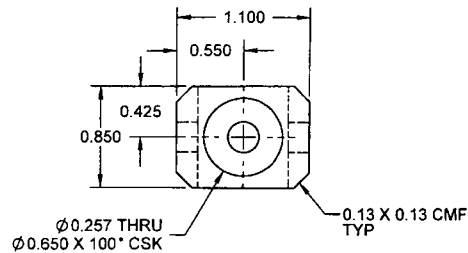
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

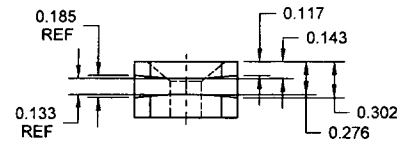
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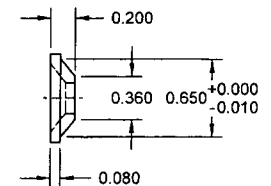
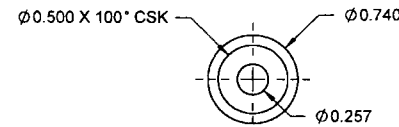
76873



**D3137-3 GUIDE**







**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELTRIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELTRIN-B)
- 5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	LAJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO15679

Purchase Order Date 12/14/11

PO Print Date 1/20/12

Page Number 1 of 3

Order From : VC-GLO001

ARCHER PRECISION INC.  
36 COLONNADE RD. N.  
NEPEAN, ON K2E 7J6  
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 226 1579	Requisition Nbr	
Vendor Fax	613 226 1719	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D3195-1P	Bracket	1/27/12 Yes	10.00 Each	Yours ppd	\$33.8200	\$338.20
		Special Inst:	AS PER DWG D3195 REV. A B76209 MATERIAL SUPPLIED BY DART				
	D3195-3P	Bracket	1/27/12 Yes	10.00 Each	Yours ppd	\$33.8200	\$338.20
		Special Inst:	AS PER DWG D3195 REV. A B76210 MATERIAL SUPPLIED BY DART				
	D4108-7P	Bracket	1/27/12 Yes	6.00 Each	Yours ppd	\$57.6300	\$345.78
		Special Inst:	AS PER DWG D4108 REV. A B76873 MATERIAL SUPPLIED BY DART				
	D3137-3P	Guide	1/27/12 Yes	20.00 Each	Yours ppd	\$26.6600	\$533.20

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 3

Change Date: 1/20/12



1393 Major Road  
Orleans, ON  
K1E 1H3

Phone # 613-899-2405

# Packing Slip

Date	Invoice #
1/24/2012	32

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	1/24/2012			

Qty	Item Code	Description
10 Sales 20 Sales		D3195-3 Bracket D3137-3 Guide HST (ON) on sales
8/10/1/31		



1393 Major Road  
Orleans, Ontario  
K1E 1H3

Telephone (613) 899-2405  
Fax (613) 226-1719

## Certificate of Compliance

To:  
Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury Ont.  
K6A 1K7

8/26/17

Po Number	Part Number	Quantities
15679	D3137-3	20
	D3195-3	

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15625 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle", is written over a horizontal line.

Alex Mazerolle  
President  
Archer Precision Inc.  
1393 Major Road,  
Orleans Ontario  
K1E 1H3